

# Work Order ID 67335

Tuesday, March 15, 2011 11:38:13 AM



Page 1

Item ID: D2330-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Frame

Start Date: 3/15/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 3/21/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

*CL*

Date: 11/03/15

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2330

H

100

0.00



Large Fab

Memo

0.00

Large Fab

1- Cut tube as per dwg D2330  
2- remove identification marks and deburr

*SAA 11-06-30*

*(2)*

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*6/11/07.04*

120

Identify as per dwg & Stock Location:

*3/c*

0.00



Packaging

Memo

0.00

Packaging

*6/11/07.04*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 67335**

Tuesday, March 15, 2011 11:38:13 AM



Page 2

Item ID: D2330-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Frame

Start Date: 3/15/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 3/21/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/54

mf  
11-07-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, March 15, 2011 11:38:10 AM

Page 1

Work Order ID: 67335

Parent Item: D2330-7

Parent Item Name: Frame



Start Date: 3/15/2011

Required Date: 3/21/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.09.08 new issue DD verf:EC  
10.11.30 AS PER DWG REV.H DD VERF:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304TS0.750W.065

Purchased

No

100

f

1,200.429

2.12

4,463.158



SAD

11-06-30

304 SQ Tube .75x.75x.065W

Location

Loc Qty

Loc Code

WA007

1200.4298

116267

200.4298

116763

1000

117598

4,463.2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2330-041	BASKET ASSEMBLY
3		X	D2330-043	LID ASSEMBLY
7	1		D2012-107	CLEVIS
8	4		D2235-1	RIB
9	2	2	D2252-1	FRAME
10	1	4	D2252-7	FRAME
11	2		D2253-1	LUG
12	2		D2254	GUSSET
13	1	1	D2327-3	BUSHING
14		1	D2329	LABEL PLATE
15	2	2	D2330-1	FRAME
16	1		D2330-5	FRAME
17	1		D2330-7	FRAME
18		1	D2330-15	FRAME
19	4	2	D2581	MOUNTING CHANNEL
20	3		D3748-1	HINGE HALF
21		3	D3749-1	HINGE HALF

CL 11/03/15  
WLO: 67335

RELEASED  
2010-11-25

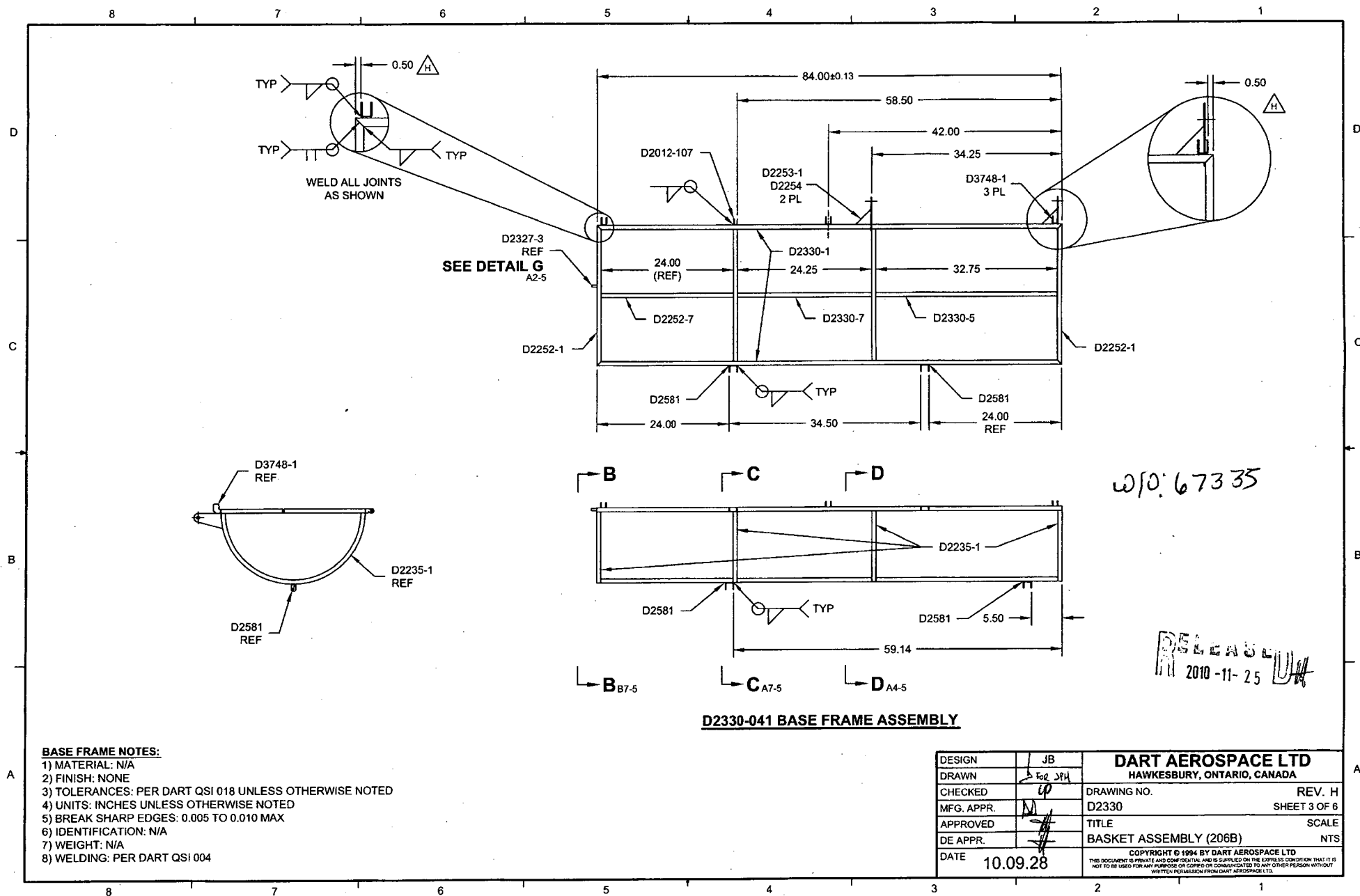
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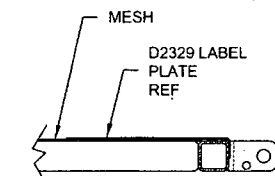
- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELDING: PER DART QSI 004

H	DIM 0.50 WAS 0.75 (ZN D2-3 & D6-3) REF NCR 10-346	JPH	10.09.28
G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 20 AND 21 REPLACE D2232-1/-3; STRETCHED LID FROM 83.27" TO 84.00"; ITEMS 9 & 10 REPLACE D2330-3/-9/-13; ITEM 13 (ON LID) REPLACES D2327-1; REORGANIZED ALL SECTION & DETAIL VIEWS. REASON: SEE PAR#09-006.	MB	09.02.05
F	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 6 ADDED. FRAME MATERIAL THICKNESS WAS 0.060.	AJS	08.08.11
E	INCORPORATED D1, D2253-1 WAS D2253 (NCR 533).	KE	05.11.10
D	MODIFIED LATCH, REDRAWN	KE	99.09.14
C	ADDED LATCH AND LABEL PLATE	BK	96.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JL		
CHECKED	JP	DRAWING NO.	REV. H
MFG. APPR.	JP	D2330	SHEET 1 OF 6
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	BASKET ASSEMBLY (206B)	NTS
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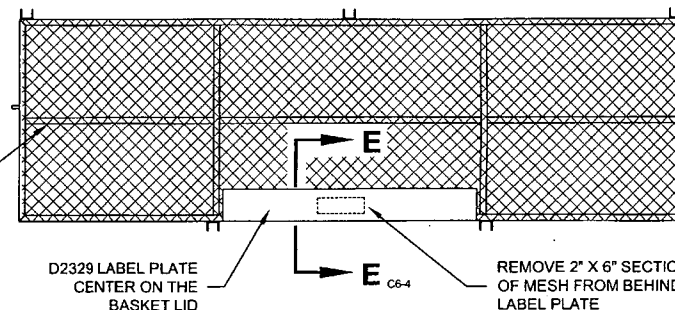




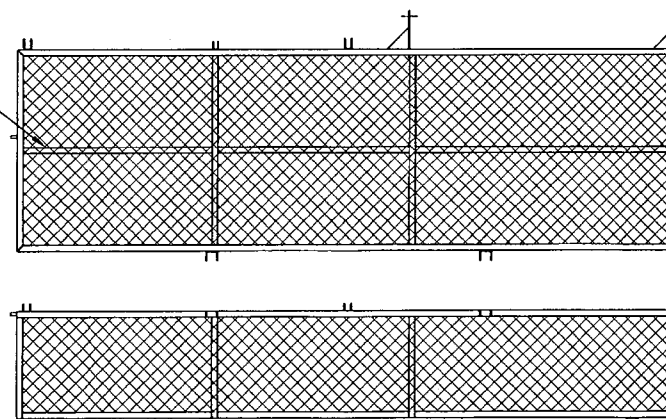


**SECTION E-E** C3-4  
VIEW ROTATED 90° CCW

TACK WELD EACH  
STRAND END OF  
MESH TO FRAME



**D2330-043 LID ASSEMBLY**

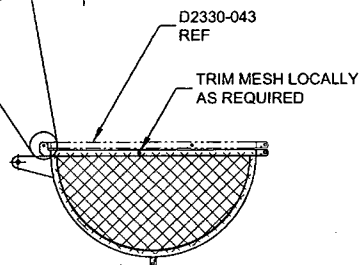
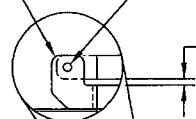


**D2330-041 BASE ASSEMBLY**

D3748-1  
3 PL, REF

TRANSFER MARK FROM D3749-1  
HINGE HALF ON D2330-043 LID ASSY,  
DRILL Ø0.261 THRU

0.200 PRIOR  
TO DRILLING Ø0.261 HOLE  
THRU D3748-1 AND D3749-1



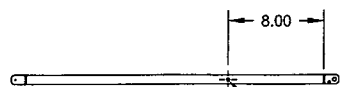
**ASSEMBLY NOTES:**

- 1) MATERIAL: SEE SHEET 1 FOR MESH MATERIAL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

W10.67335

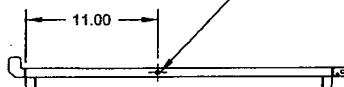
**RELEASED**  
2010-11-25

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2330	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206B)	NTS
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**VIEW A-A** A6-2

DRILL 3/8 HOLE AND  
INSTALL D2327-3  
SEE DETAIL G A2-5



**VIEW B-B** A5-3

D2581  
REF

D2012-107  
REF

D2581  
REF

D2253-1  
REF

EXPANDED  
METAL

WELD D2581  
WITH LARGE HOLE  
ON THIS SIDE

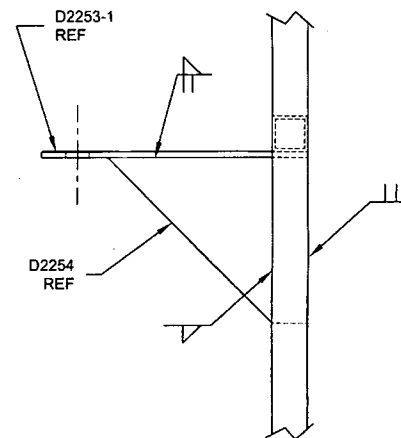
**SECTION C-C** A4-3

C2-5  
F

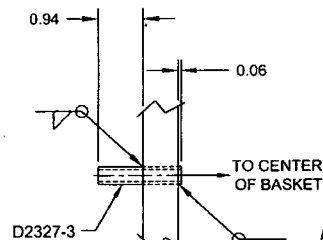
D2253-1  
REF

EXPANDED  
METAL

**SECTION D-D** A3-3



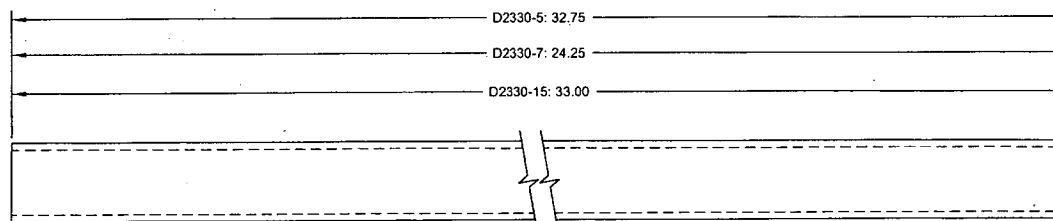
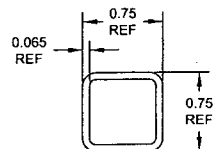
**VIEW F-F** B6-5  
SCALE 4X



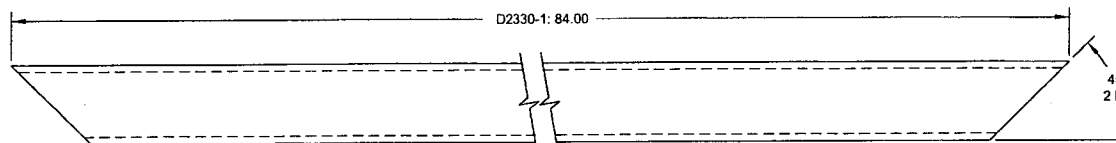
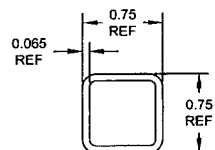
**DETAIL G**  
SPACER INSTALLATION  
SCALE 4X

RELEASED  
2010-11-25

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DRAWN	A FOR JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MP	DRAWING NO.	REV. H
MFG. APPR.	MP	D2330	SHEET 5 OF 6
APPROVED	MP	TITLE	SCALE
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D2330-5 FRAME  
D2330-7 FRAME  
D2330-15 FRAME



D2330-1 FRAME

W10.67335

RELEASED  
 2010-11-25

- NOTES:**  
 1) FRAME MATERIAL: SEE SHEET 1  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: N/A

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2330	SHEET 6 OF 6
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